

shy today

Work Order ID 85296

85296

Page 1

June-05-12 2:19:40 PM

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 6/05/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/06/12 Req'd Qty: 1.00 *1*

Customer: CU-DAR001

Reference: RMA RA111368

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3391	I
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100

0.00

100

QC

Quality Control

Memo

INSPECT RA111368
1 X D3391-025 B80281

0.00

8.26665

110

0.00

110

HandFinish

Hand Finishing

Memo

REMOVE CAPS...DESTROY/SCRAP
ASSEMBLE NEW CAP ON TUBE
D2646 B 78018
SIKAFLEX B 11123409
TOUCH UP IF REQUIRED

0.00

1 x 16 12/10/12

Work Order ID 85296

85296

Page 2

June-05-12 2:19:40 PM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 6/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/06/12 Req'd Qty: 1.00 ***1*** Customer: CU-DAR001
 Reference: RMA RA111368

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120		0.00							
QC	Memo								
Quality Control									
130		0.00							
130		0.00							
Packaging	Memo								
Packaging	RE-IDENIFY USING NEW B/N								
140	QC21- Final Inspection - Work Order Release	0.00							
140		0.00							
QC	Memo								
Quality Control									

(Handwritten signature)

MS 12/06/05
MF 12-06-05

Picklist Print

June-05-12 2:19:39 PM

Page 1

Work Order ID: 85296

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/05/12

Required Date: 6/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H 11.11.14 AS PER REV.I
 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2646 Aft Cap		Manufactured	No				Each	69.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		69							
				62678		5							
				68280		5							
				70945		1							
				71070		2							
				73294		1							
				73825		2							
				78018		3							
				79562		12							
				81974		38							
D3391-025 Aft Tube Assembly		Manufactured	No				Each	0.0000					

Handwritten signature and date 11/06/07

Handwritten mark 'x1'

Handwritten signature and date 1380281 x11 11/06/08

RA 111368

Received @ Dart June 5th, 2012
Inspected @ Dart June 5th, 2012

Customer: Bristow US LLC
Customer Contact: Lynn Castille
Shipped from: New Iberia LA USA

Instructions for RA111368 D3391-025 B80281

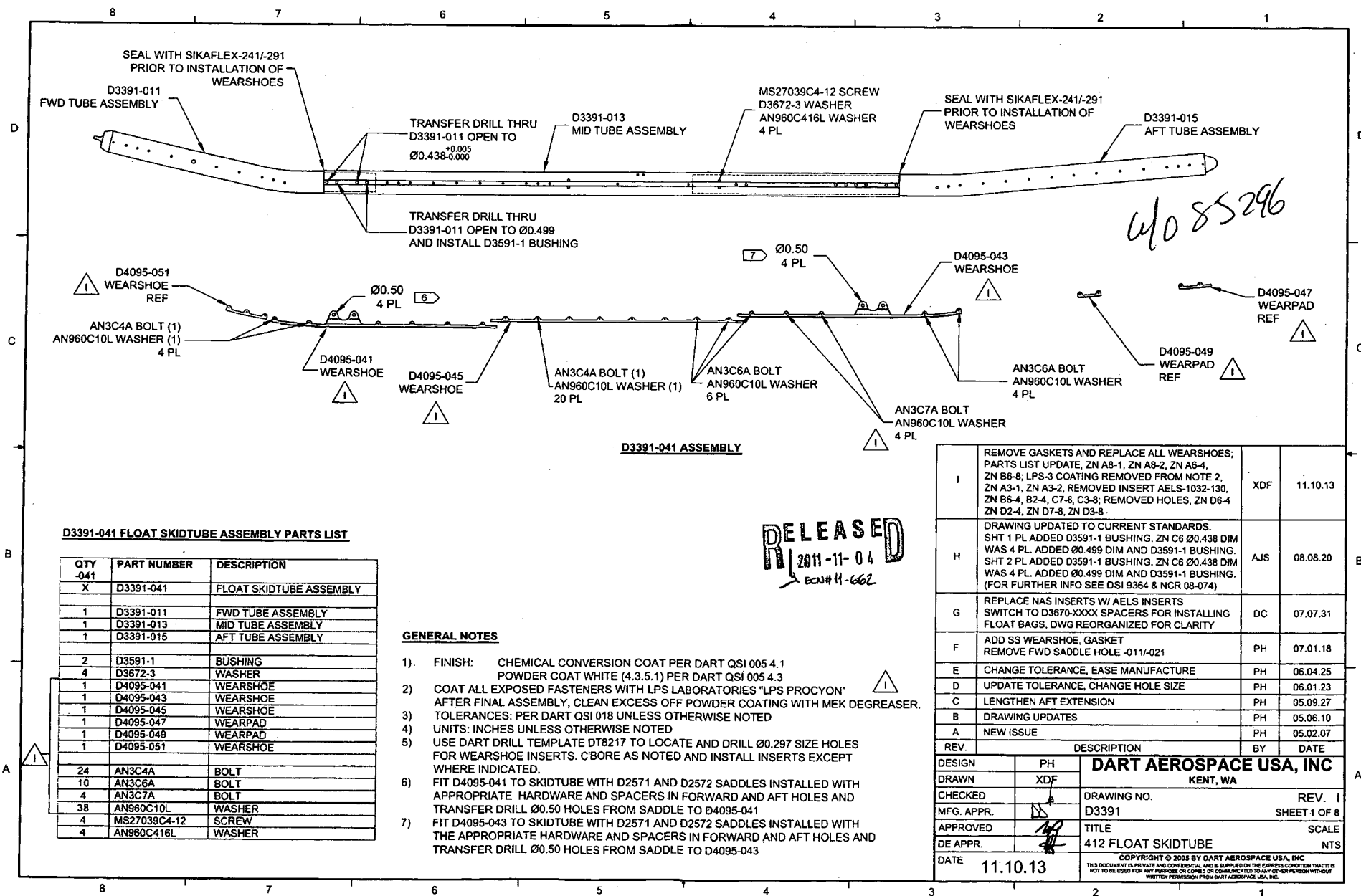
- Aft cap needs to be replaced see pictures
- Clean up after reassembly
- All work needs to be done on new work order
- Restock under new Batch #

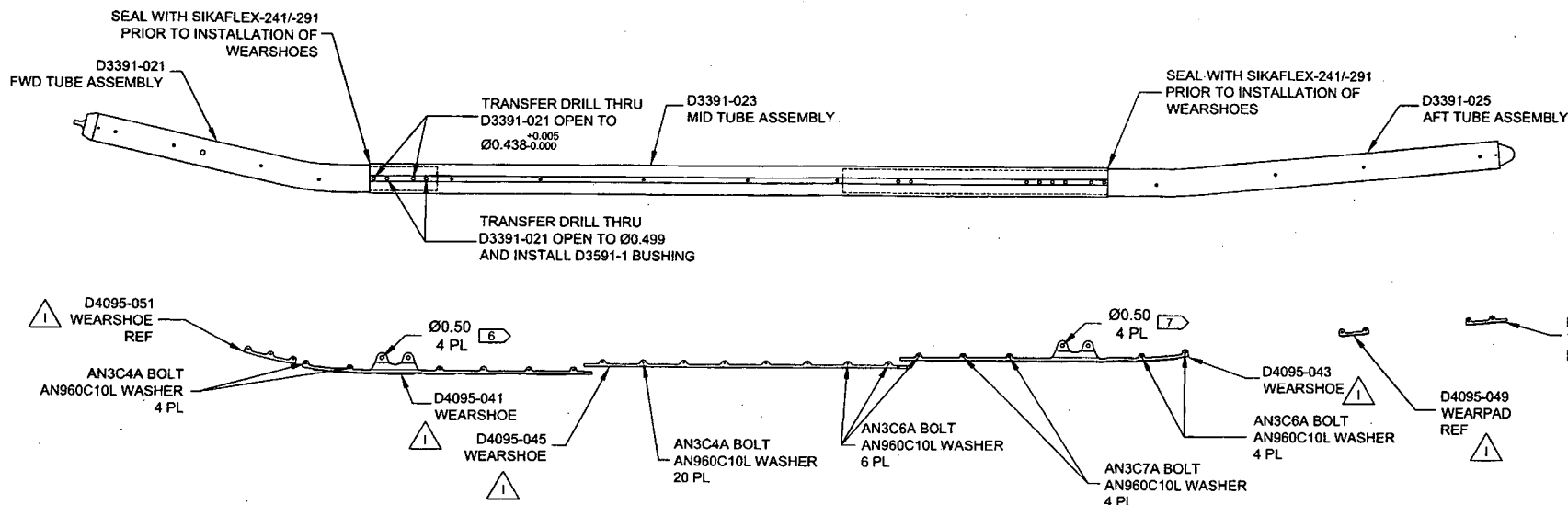
Time Estimate = 2 HOURS

Departments Required: Finishing (reworking) & Stores (restocking)

Pictures Attached = YES

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**





D3391-043 ASSEMBLY





D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

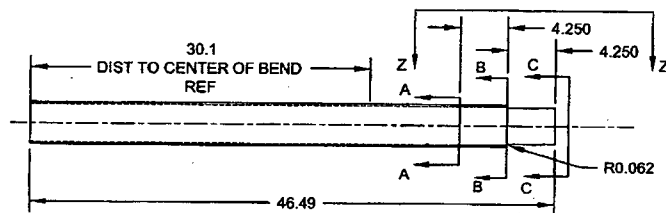
QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

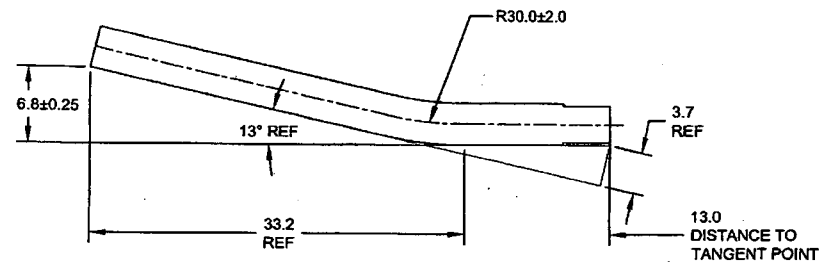
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04

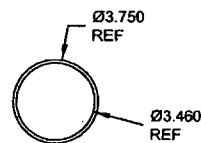
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
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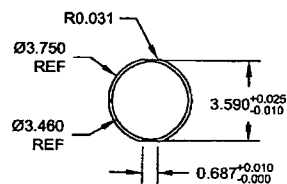
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



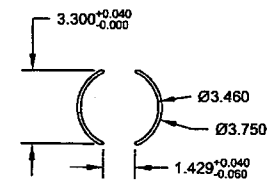
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



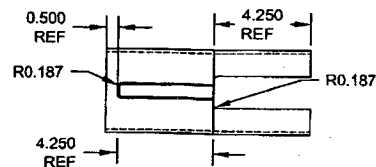
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



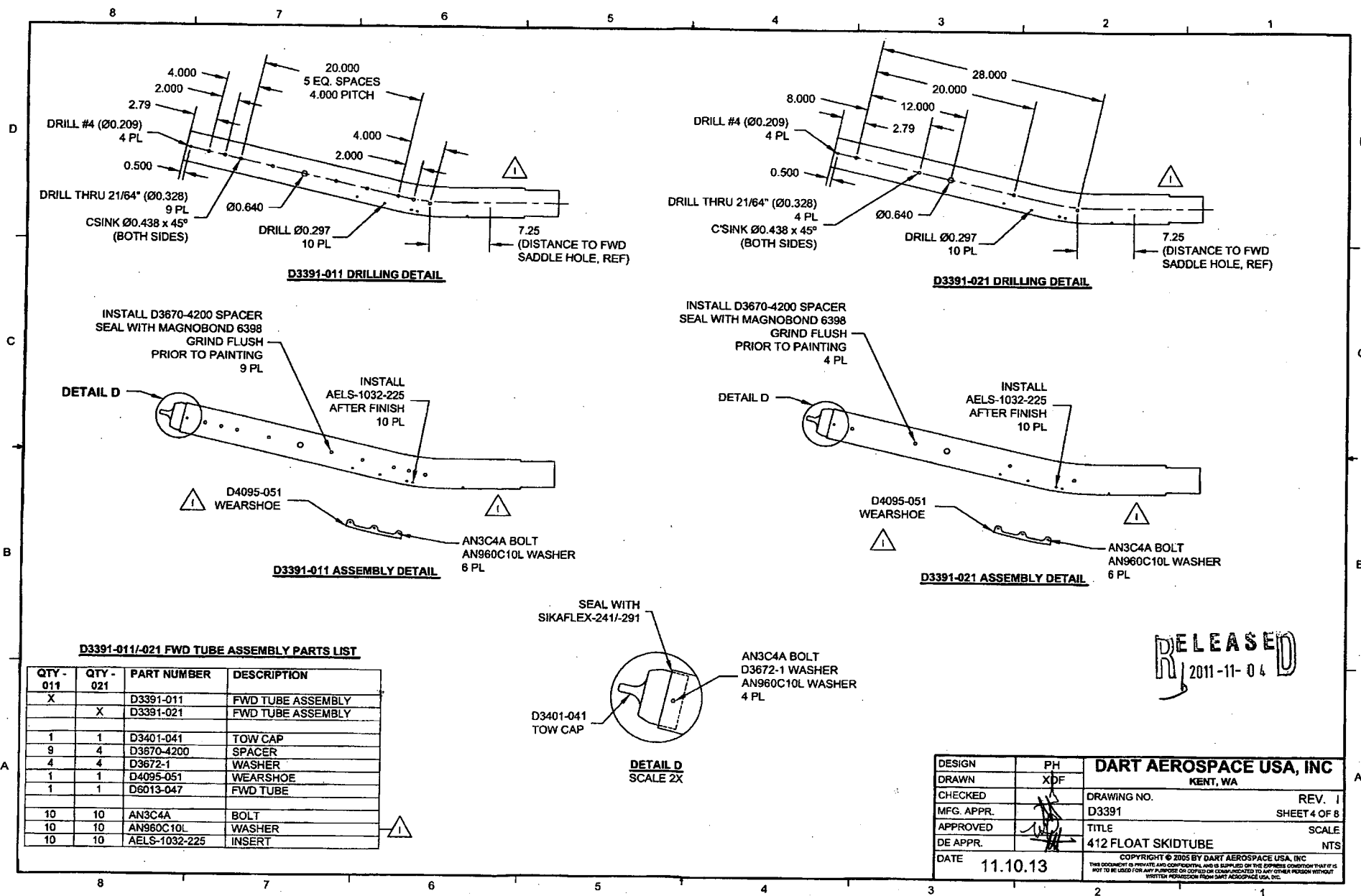
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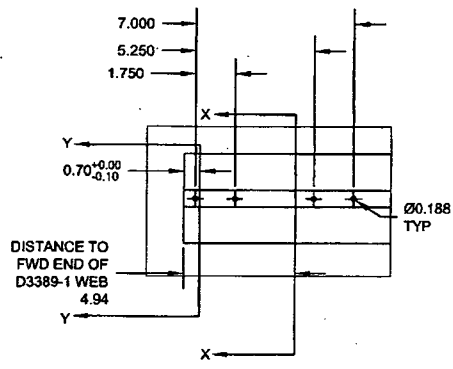
VIEW Z-Z
SCALE 2X

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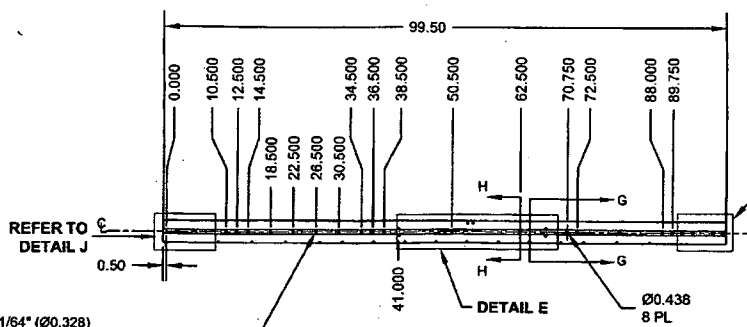
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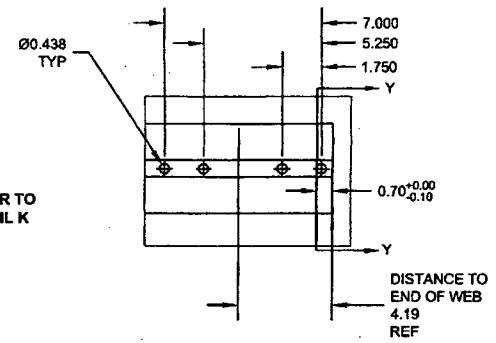
8 7 6 5 4 3 2 1



DETAIL J
SCALE 4X



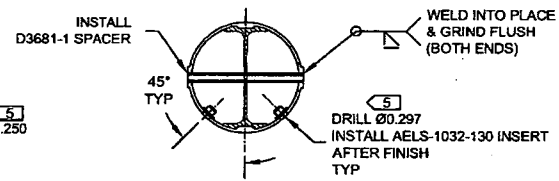
D3391-013 ASSEMBLY DETAIL
SCALE 5X



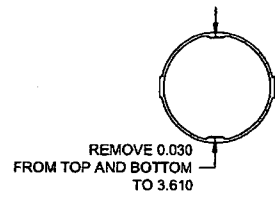
DETAIL K
SCALE 4X



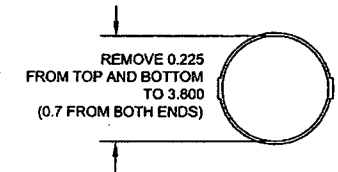
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



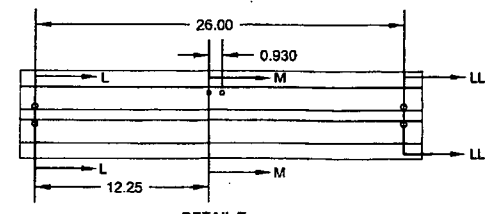
SECTION X-X
SCALE 5X



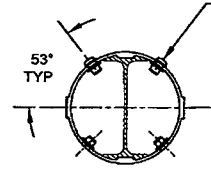
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

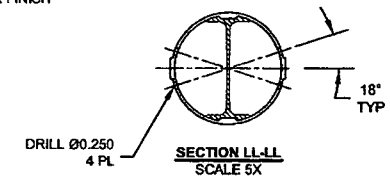
QTY	PART NUMBER	DESCRIPTION
-013	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



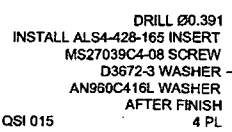
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



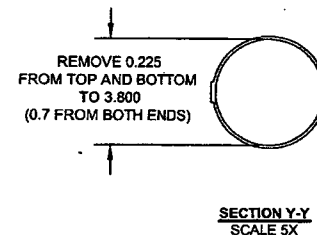
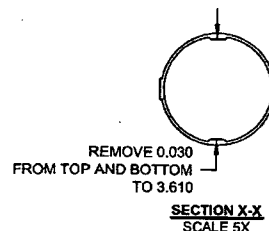
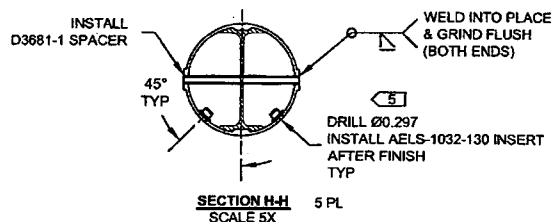
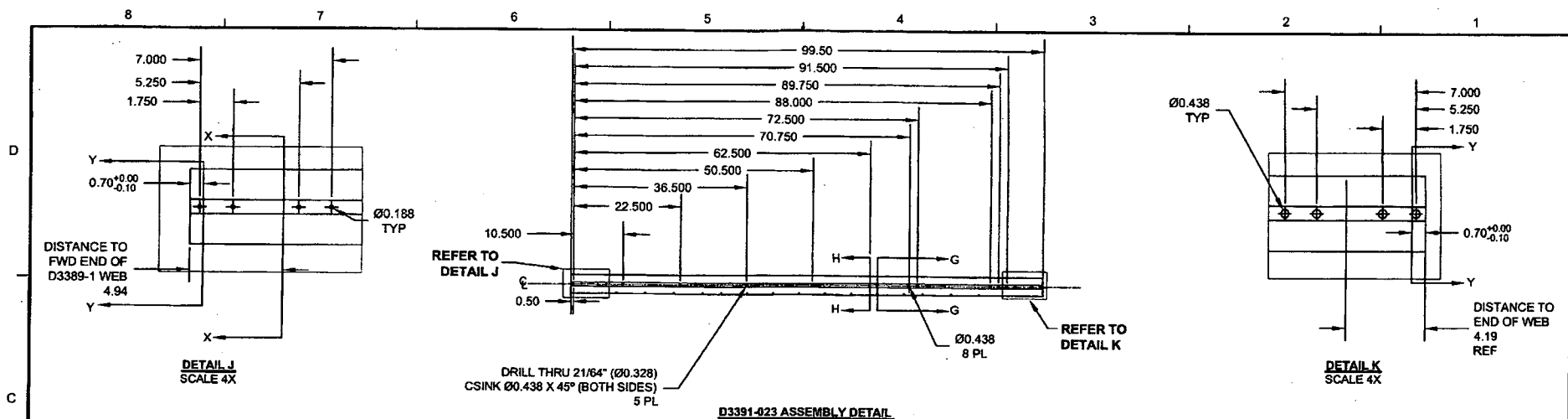
SECTION L-L
SCALE 5X

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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8 7 6 5 4 3 2 1



D3391-023 MID TUBE ASSEMBLY PARTS LIST

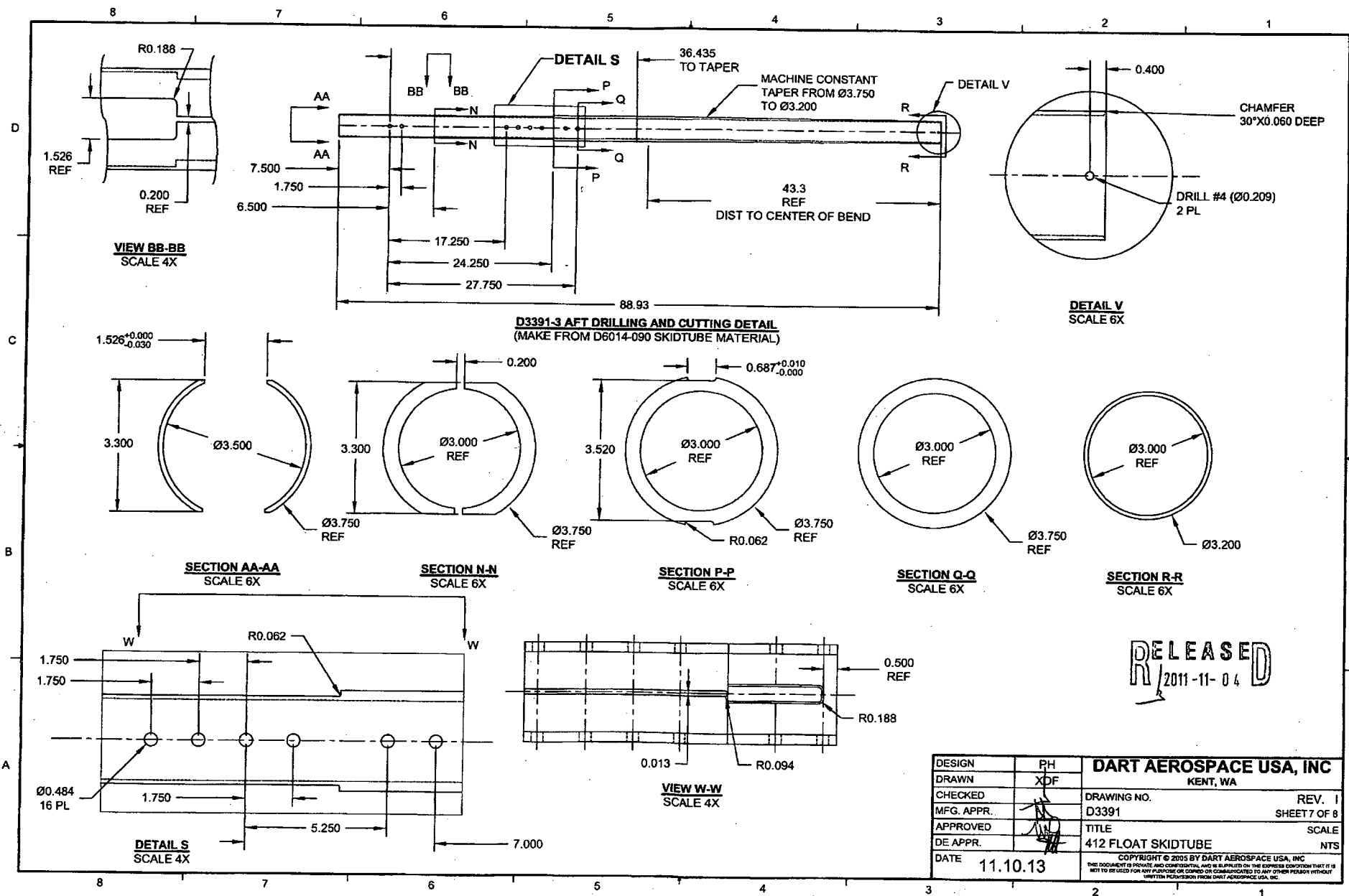
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT



D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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2011-11-04

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